

# Work Order ID 71635

Thursday, July 07, 2011 11:22:31 AM



Page 1

Item ID:	D3255-042	Accept		Setup	Start	
Revision ID:				Stop		
Item Name:	Access Panel Assembly					
Start Date:	7/7/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	7/21/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>11-07-07</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:		Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3255	Rev B								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld as per Dwg D3255 ***purge weld***A/R SS ROD Batch: <u>M115728</u> □2-Grind Welds Flush								
110		0.00							
	QC10- Inspect visual per QSI004- ground welds								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

11.07.11

-042

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71635**

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Item ID: D3255-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Access Panel Assembly

Start Date: 7/7/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

150

Small Fab

0.00



Small Fab

Small Fab

Memo

1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg

D3255 A/R 736 DOW CORNING ADHESIVE

Batch: 1116664

4X ~~Ø~~ M-1 11/07/124 ~~Ø~~ BL 11-7-12

(4)

SP 11/07/14

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 07, 2011 11:22:28 AM

Page 1

Work Order ID: 71635

Parent Item: D3255-042

Parent Item Name: Access Panel Assembly



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-2  Panel		Manufactured	No			100	Each	4.0000	1	4		7/11/11	
<div> <div>Location</div> <div>WA</div> <div>69054</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3255-5  Gasket		Manufactured	No			100	Each	8.0000	1	4		Sp 11/07/11	
<div> <div>Location</div> <div>GA</div> <div>68783</div> </div> <div> <div>Loc Qty</div> <div>8</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3255-3  Cap		Manufactured	No			150	Each	11.0000	1	4		7/11/11	
<div> <div>Location</div> <div>WA021</div> <div>66812</div> </div> <div> <div>Loc Qty</div> <div>11</div> <div>11</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

20

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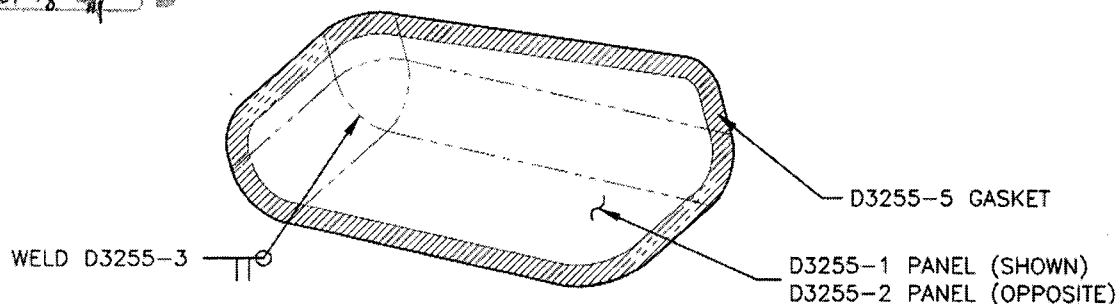
**NOTE:** Date & initial all entries



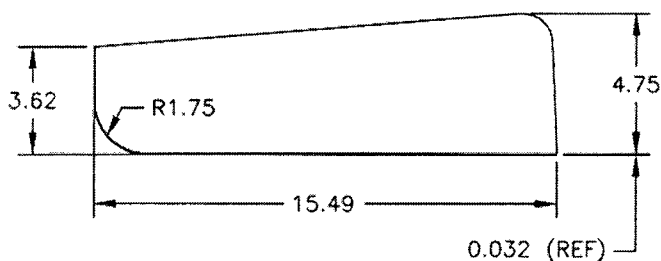
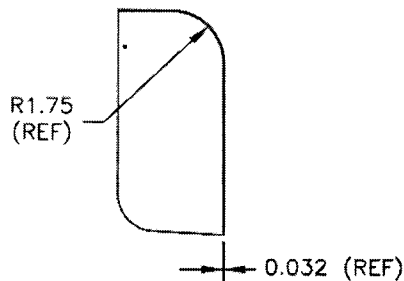
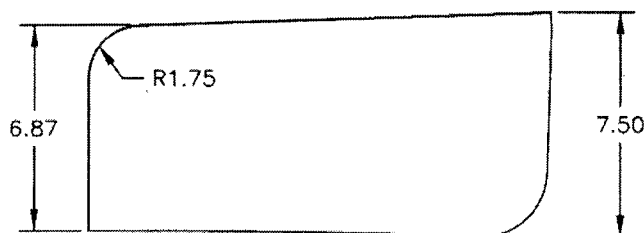


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED  
05.01.18 #



**D3255-041 ACCESS PANEL (SHOWN)**  
**D3255-042 ACCESS PANEL (OPPOSITE)**



# 71635

**D3255-1 BEND DETAIL**  
**D3255-2 OPPOSITE**

**D3255-041/-042 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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# Dart Aerospace Ltd

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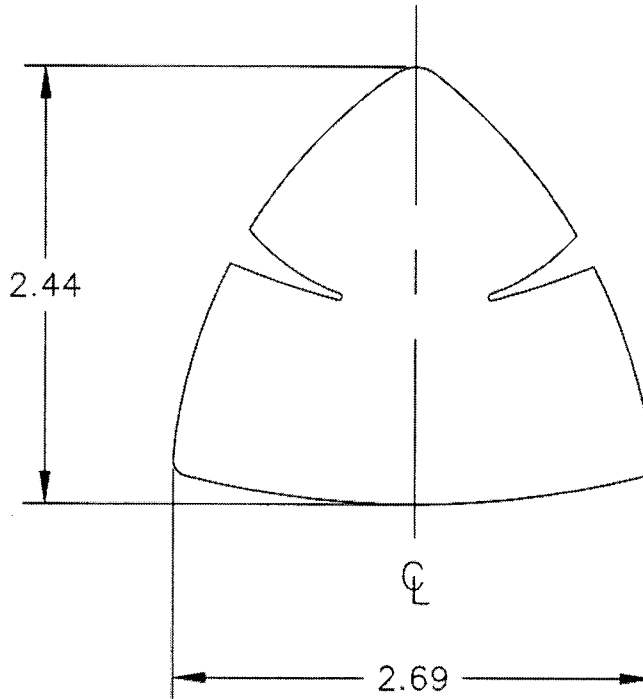
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**NOTE:** Date & initial all entries



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DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED  
05-01-08 #



**D3255-3 CAP**  
**FORM TO FIT D3155-1/-2**

# 71635

**D3255-3 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

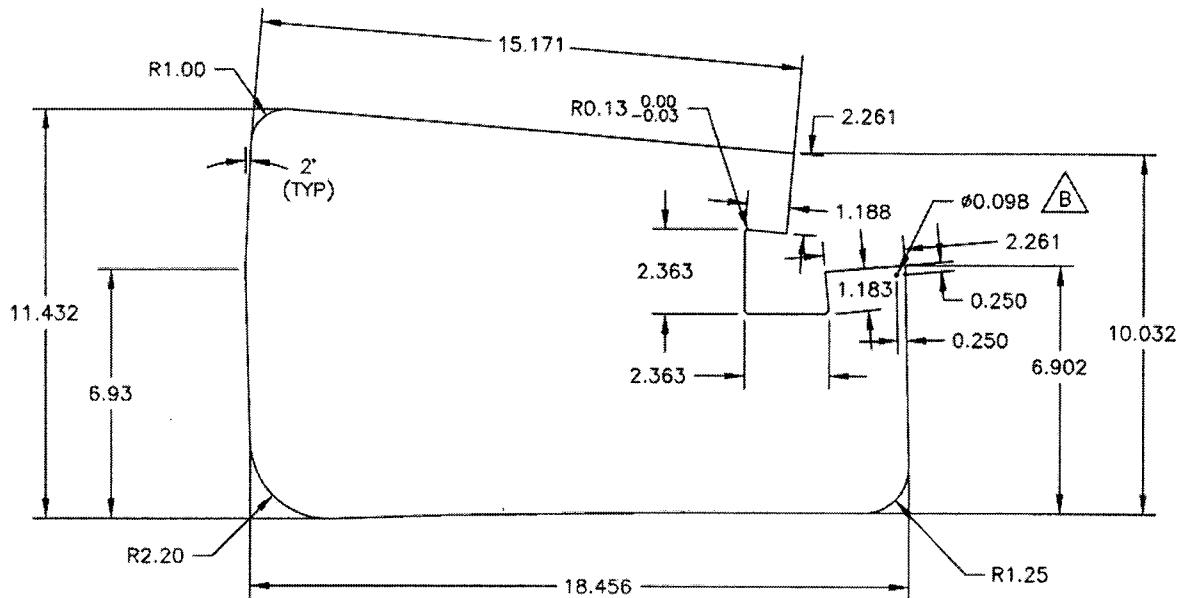
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CHECKED UP	APPROVED RT	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05-01-18



**D3255-1/-2 FLAT PATTERN**

**D3255-1/-2 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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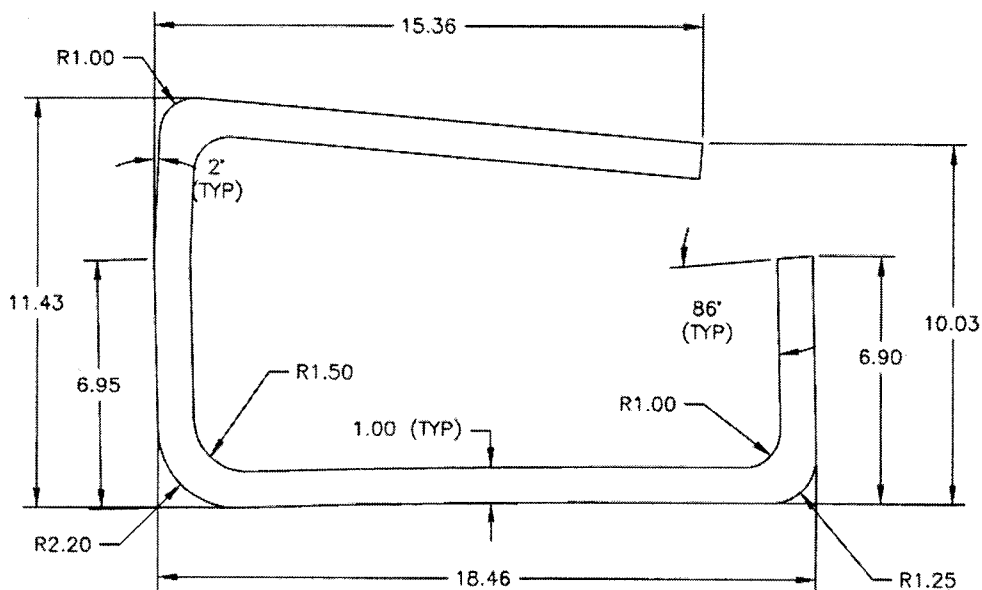
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DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05 01.18 JF



**D3255-5 GASKET**

# 71635

**D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F  
P/N SIL/F 36x36x1/16  
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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